

Ship DEC 11

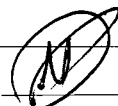
Work Order ID 138568

138568

Page 1

Tuesday, November 03, 2015 8:50:07 AM

Item ID: D4018-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Short Basket Lid Assembly (350)
 Start Date: 11/23/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/4/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: 11/10/15 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4018	D								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: 11/3/14 7 0.00

100

Large Fab

Large Fab

Memo

0.03

1- assemble ribs , weld as per dwg D4018 using DT9607B

2- weld hinge (3) and Mounting brackets as per dwg D4018
 inspect before welding mesh

3- Cut mesh as per dwg D4020-7

4- tack weld mesh on basket as per dwg D4018
 ***make sure to place mesh correctly on lid, check with label plate before
 tacking mesh***

DAS
43
9-89

DEC 09 2015

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

DEC 13 2015

DAS
24
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
OTHER : _____											

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120	QC5- Inspect part completeness to step on W/O	0.00							DAS 24 9-89
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120

QC
Quality Control

130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
-----	---	------	--	--	--	--	--	--	--

130

Powdercoat
Powder Coating

M127890

Memo 0.00

*** mask sides of hinge prior to powdercoat***

Start Time: *10:15*

Oven Temperature: *320°*

Finish Time: *10:45*

1 of 15-12-10 *DAS 34 9-89*

140	Wing Walk as per dwg QSI005 4.4 Batch <i>14133536</i>	0.00							
-----	---	------	--	--	--	--	--	--	--

140

HandFinish
Hand Finishing

Memo 0.01

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

Install placard and label as per dwg

*** Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

1 of 20 15/12/10

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Work Order ID 138568

Tuesday, November 03, 2015 8:50:07 AM

138568

Page 3

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Revision ID: Stop ***NS2***
Item Name: Short Basket Lid Assembly (350)
Start Date: 11/23/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/4/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							DAS 38 9-80
150									
QC	Memo	0.00							DEC 10 2015
Quality Control									
160	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MLJ DEC 1.1 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Picklist Print

Tuesday, November 03, 2015 8:50:25 AM

Page 1

Work Order ID: 138568

138568

Parent Item: D4018-041

D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 11/23/2015

Required Date: 12/4/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP REV:E 13.08.21 DWG REV.D / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	673.3200	8.4578	8.4578			

✓ ***M304FX0 75-16F***
Expanded Metal Flat SS

****4133466 → 14.5006 DEC 09 2015**

Location	Loc Qty	Loc Code	DAS
WA004	673.32		43 9-89
M132745	30		
M132864	3.2		
M132967	0.12		
M133198	320		
M133466	320		

D4018-1 Manufactured No

100 Each 0.0000 2 2

✓ ***D4018-1***
Rib

****B139799 → 2x DAS 43 9-89 DEC 08 2015**

D4018-3 Manufactured No

100 Each 4.0000 2 2

✓ ***D4018-3***
Rib

****B136832 → 2x DAS 43 9-89 DEC 08 2015**

Location	Loc Qty	Loc Code
WA004	4	
136832	4	

D4016-3 Manufactured No

100 Each 16.0000 3 3

✓ ***D4016-3***
Hinge Half, Lid

****B138084 → 3x DAS 43 9-89 DEC 08 2015**

Location	Loc Qty	Loc Code
WA004	16	
136976	16	

DQA: _____ Date: _____



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Work Order ID: 138568

138568

Parent Item: D4018-041

D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 11/23/2015

Required Date: 12/4/2015

Start Qty: 1.00

Required Qty: 1.00

D4018-5 Manufactured No

100 Each 6.0000 6 6

✓ ***D4018-5***
Rib

****B133880 → 3x**
B135993 → 3x

DAS
43
9-89

DEC 08 2015

Location	Loc Qty	Loc Code
WA004	6	
133880	3	
135993	3	

D4035-043 Manufactured No

100 Each 4.0000 2 2

✓ ***D4035-043***
Lid Rib Assembly, Aft (350 Basket)

****B139741 → 2x**

DAS
43
9-89

DEC 08 2015

Location	Loc Qty	Loc Code
WA004	4	
132486	4	

D2581 Manufactured No

100 Each 40.0000 2 2

✓ ***D2581***
Mounting Bracket

****B137794 → 2x**

DAS
43
9-89

DEC 08 2015

Location	Loc Qty	Loc Code
WA004	40	
132771	26	
136270	14	

D4021-3 Manufactured No

100 Each 3.0000 1 1

✓ ***D4021-3***
Data Plate

****B137760 → 1x**

DAS
43
9-89

DEC 08 2015

Location	Loc Qty	Loc Code
WA004	3	
133179	3	

D2728-3 Manufactured Yes

140 Each 0.0000 0 0

D2728-3
Dart Logo Label Large

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

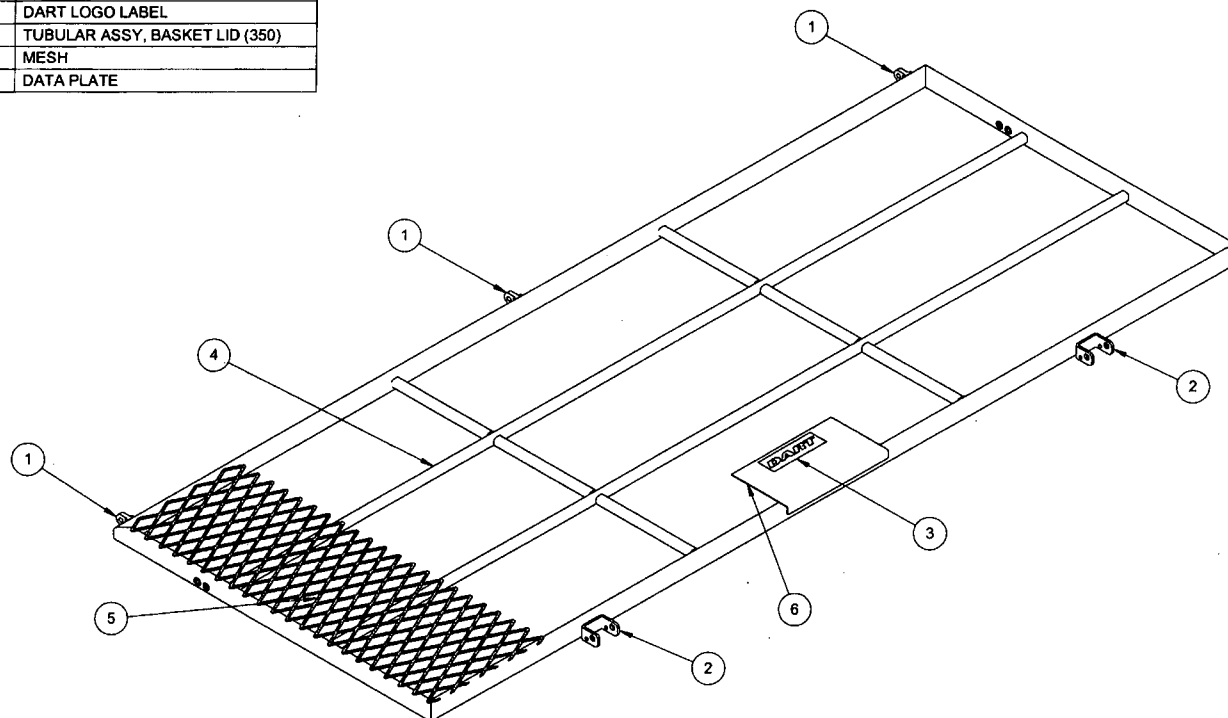
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LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

ITEM	QTY	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE

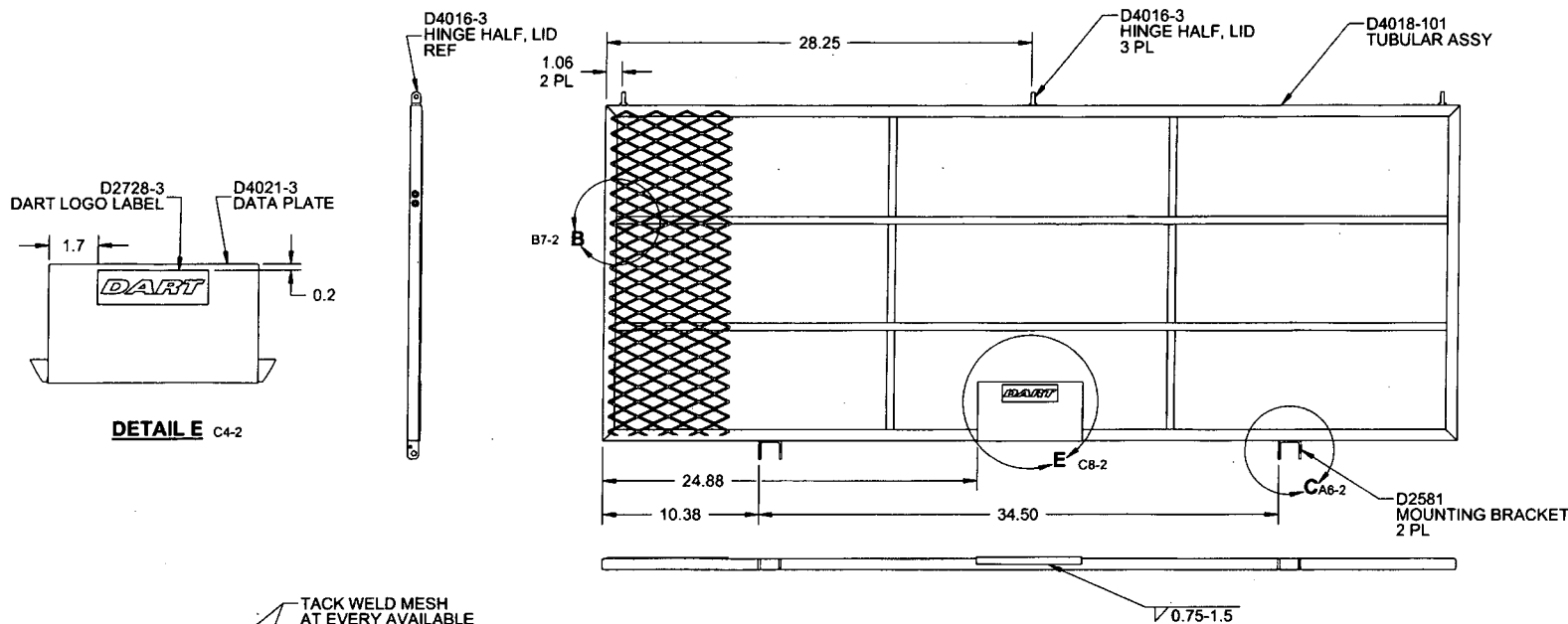


D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

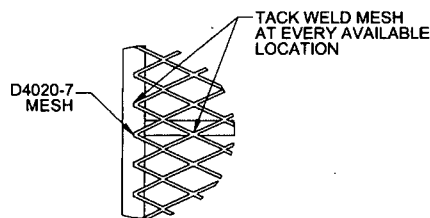
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2013-08-16

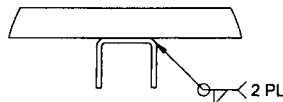
D	C7-3 D4035-043 WAS D4035-041 (REASON: PROPARM OPTION DELETED)	AJS	13.07.18
C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-807-2 REV. C AND D350-807-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	YJ	DRAWING NO.	REV. D
MFG. APPR.		D4018	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350)	NTS
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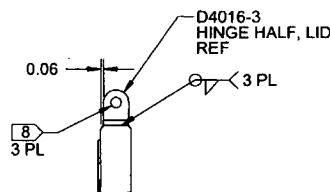
DETAIL E C4-2



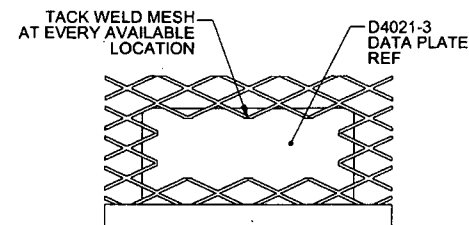
DETAIL B C6-2



DETAIL C C3-2



DETAIL D D1-2



VIEW A-A C1-2

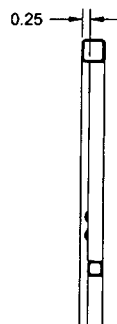
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.5 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4018	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET LID ASSY (350) NTS	
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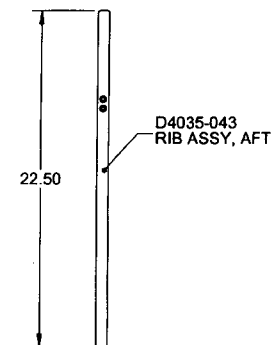
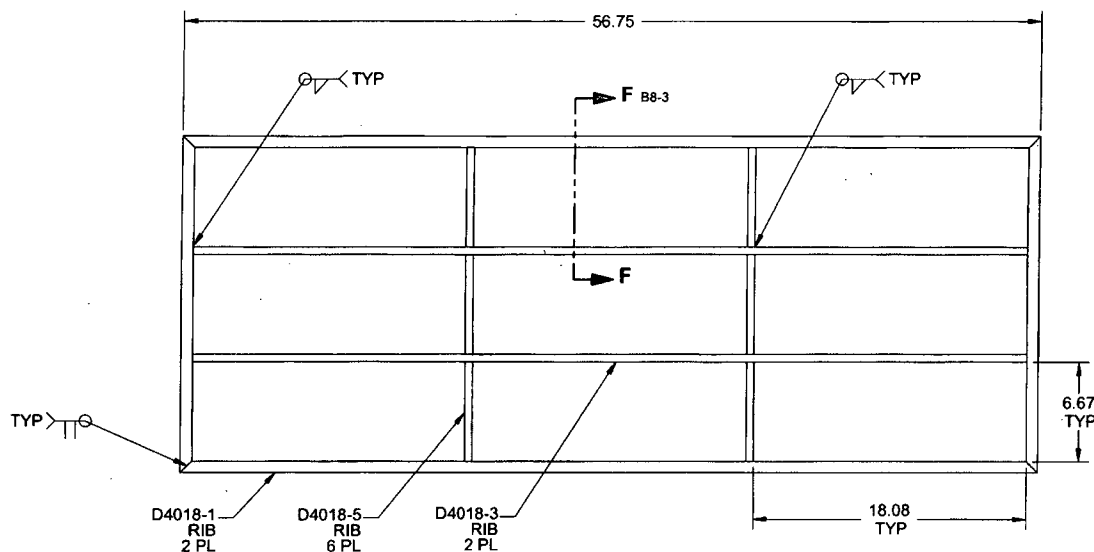
RELEASED
2013-08-16

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



SECTION F-F C3-3

D4035-043
RIB ASSY, AFT



D4035-043
RIB ASSY, AFT

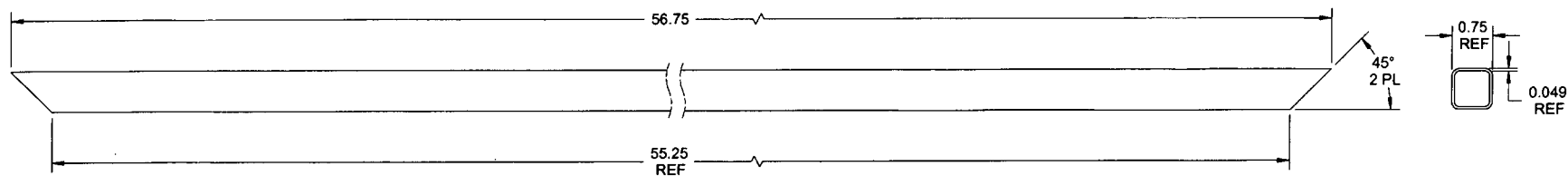
D4018-101 TUBULAR ASSY, BASKET LID (350)

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2013-08-16

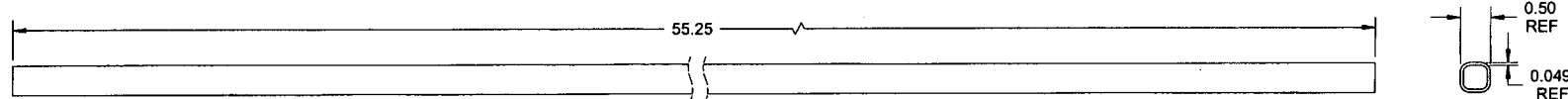
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

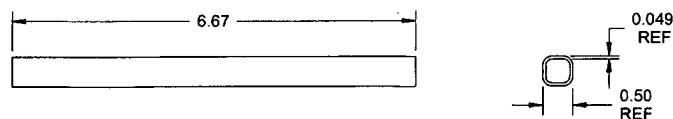
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4018	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET LID ASSY (350)	NTS
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D4018-1 RIB



D4018-3 RIB



D4018-5 RIB

NOTES:

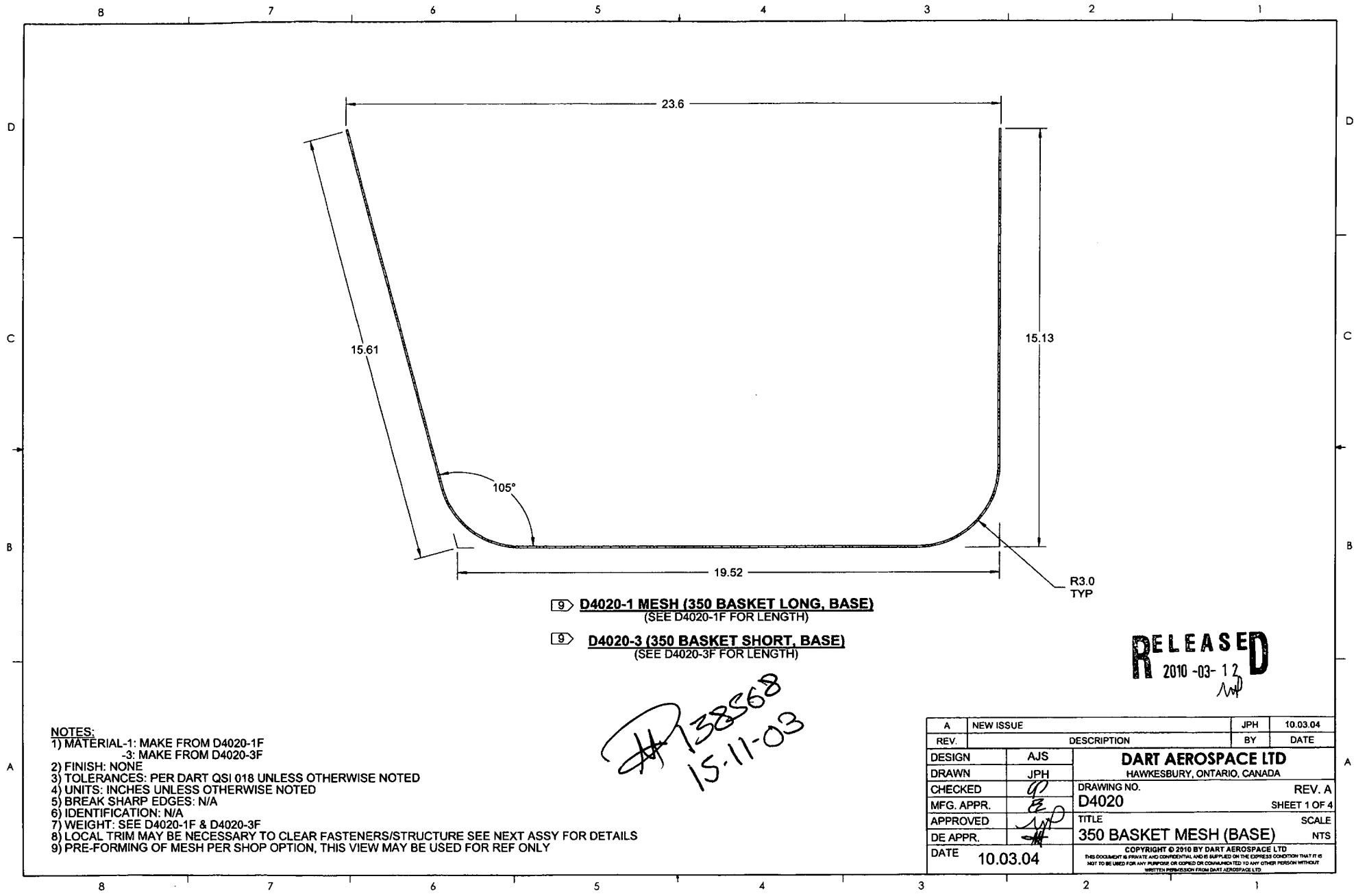
1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2013-08-16
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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4018	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET LID ASSY (350)	NTS
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9 D4020-1 MESH (350 BASKET LONG, BASE)
(SEE D4020-1F FOR LENGTH)

9 D4020-3 (350 BASKET SHORT, BASE)
(SEE D4020-3F FOR LENGTH)

R3.0
TYP

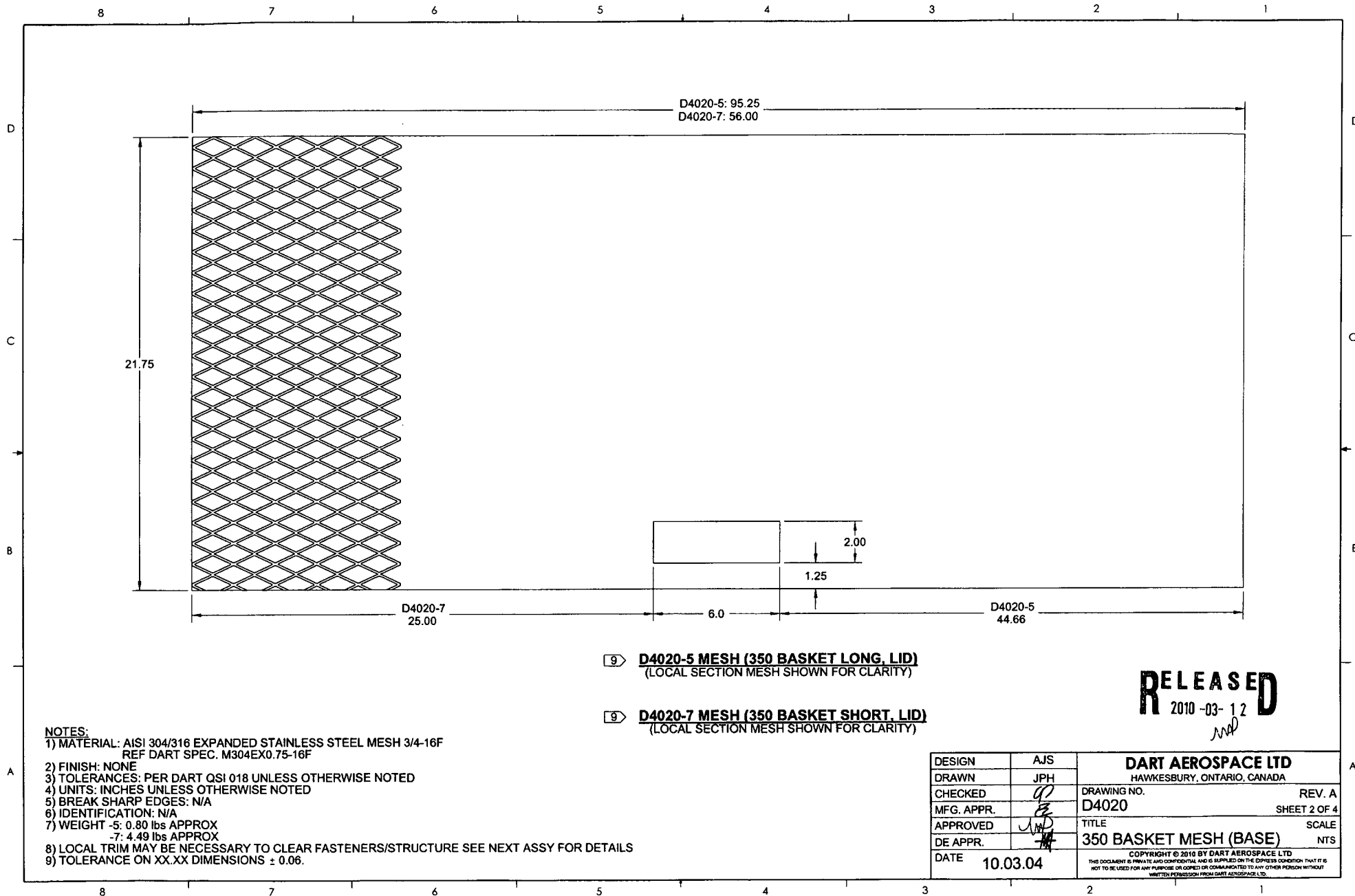
RELEASED
2010-03-12

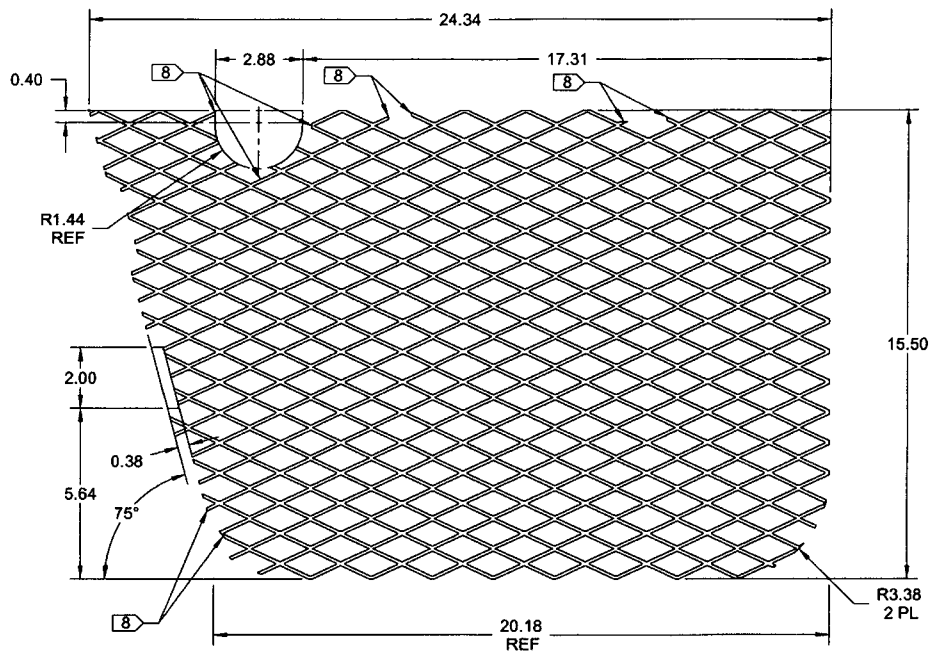
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15-11-03

NOTES:

- 1) MATERIAL-1: MAKE FROM D4020-1F
-3: MAKE FROM D4020-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4020-1F & D4020-3F
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

A NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	EP	D4020	SHEET 1 OF 4
APPROVED	W/P	TITLE	SCALE
DE APPR.	W/P	350 BASKET MESH (BASE)	NTS
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9 D4020-11 END MESH, BASKET

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

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2010-03-12
MP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JP	DRAWING NO. D4020	REV. A
MFG. APPR.	JP	SHEET 3 OF 4	
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 BASKET MESH (BASE)	NTS
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